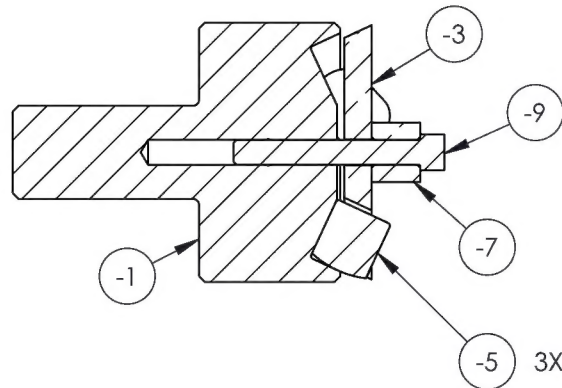
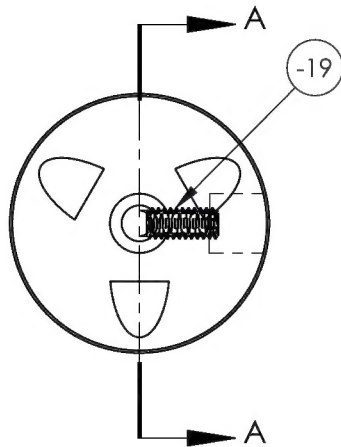
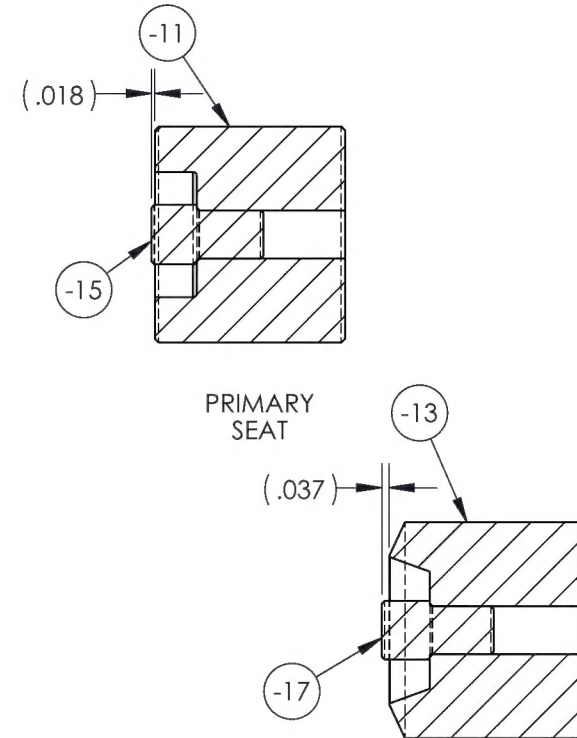


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0185	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D SPECIFICATION WAS Ø1-1/2 X 1-7/8 IS Ø1-3/8 X 1-7/8. CH'D ENGRAVE NOTE, CH'D DIM WAS #8-32 ∇ .675 IS #8-32 UNC -2B ∇ .187 ∇ .31. -9 CH'D MATERIAL WAS 01 IS STEEL, CH'D SPECIFICATION WAS Ø3/8 X 1-1/8 IS MCMASTER-CARR #98378A909 (MODIFIED). CH'D DIM WAS Ø241 IS (Ø.188), WAS Ø.129 +.000 -.001 IS (Ø.129). -11 CH'D ENGRAVE NOTE. -13 CH'D ENGRAVE NOTE.	10/15/2014	DJN	JAG



SECTION A-A



PRIMARY SEAT

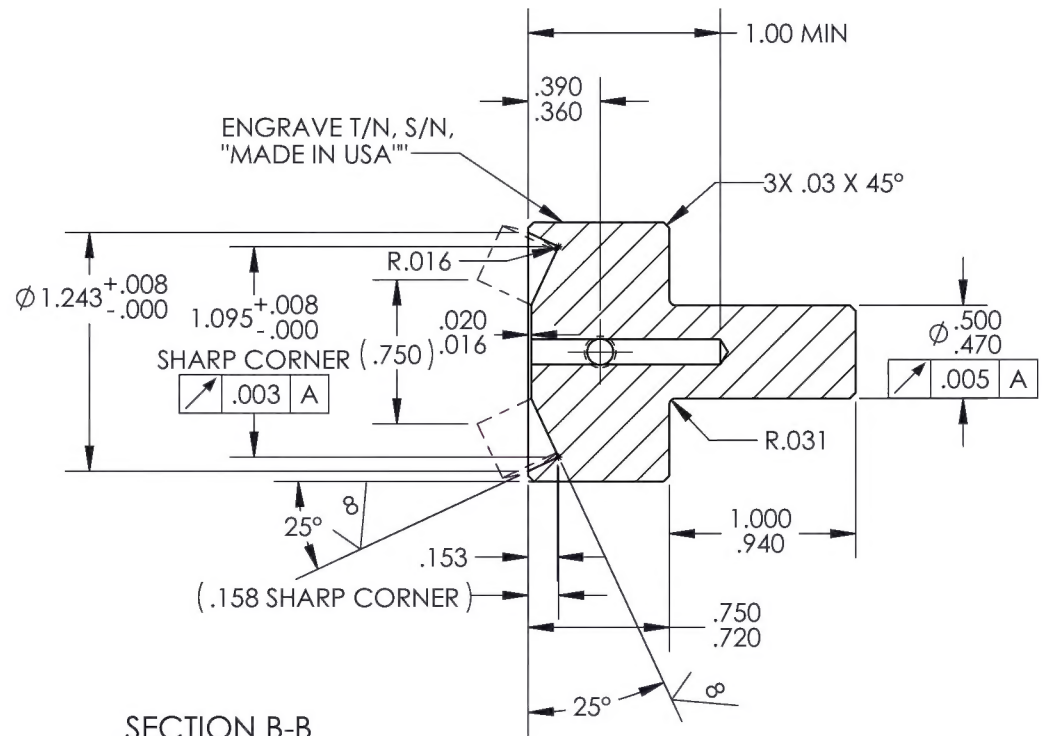
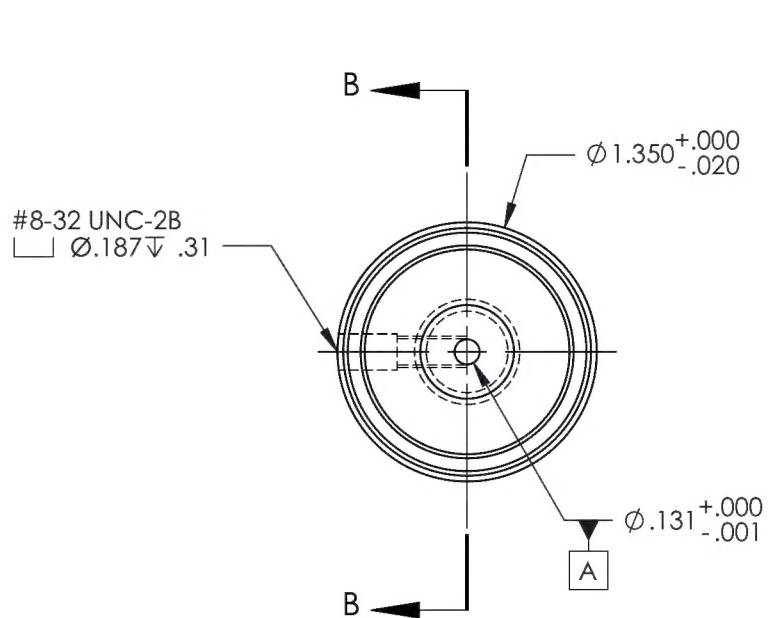
SECONDARY SEAT

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ROLLER FIXTURE	DRILL ROD	Ø1-3/8 X 1-7/8	2
			-3	1	RETAINER	BRONZE RND BAR	Ø1-1/2 X 1/4	3
			-5	3	ROLLER	STEEL	GAUGE PIN MSC #89031009	4
			-7	1	GUIDE	BRONZE RND BAR	Ø1/2 X 3/8	5
			-9	1	PIN	STEEL	MCMASTER-CARR #98378A909 (MODIFIED)	6
			-11	1	PRIMARY SEAT	4140 Q & T	Ø1-1/4 X 1-1/8	7
			-13	1	SECONDARY SEAT	4140 Q & T	Ø1-1/4 X 1-1/8	8
			-15	1	LOCATING PIN	1018	Ø3/8 X 3/4	9
			-17	1	LOCATING PIN	1018	Ø3/8 X 3/4	10
		B/O	-19	1	SOCKET HEAD SET SCREW	S.S.	8-32 X 3/8 MCMASTER-CARR #97705A406	1

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: GILBERT APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL 212-310-701-103
SCALE 1:1	DATE 3/29/2011
SHEET 1 OF 10	

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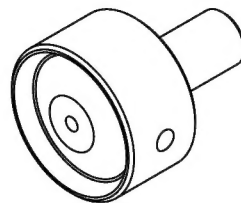
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0185	-1 CH'D ENGRAVE NOTE, CHG'D DIM WAS #8-32 ∇ .675 IS #8-32 UNC -2B \square \varnothing .187 ∇ .31.	10/15/2014	DJN	JAG



SECTION B-B

NOTES:

1. ROLLER RACE SURFACES MUST HAVE SMOOTH APPEARANCE, FREE FROM MACHINING MARKS AND GROOVES.
2. DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.



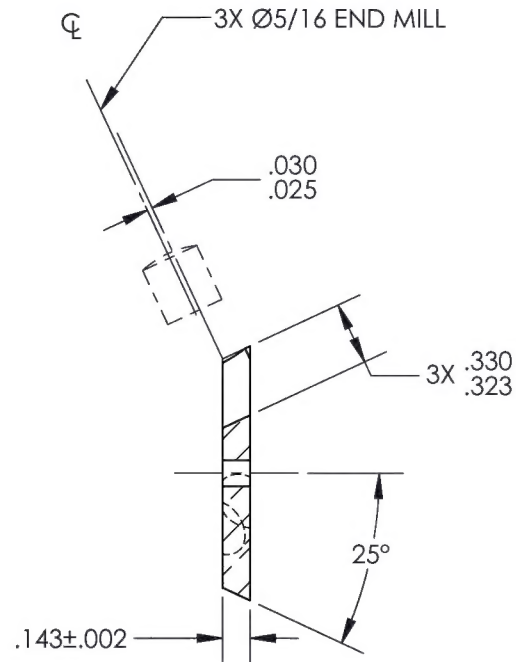
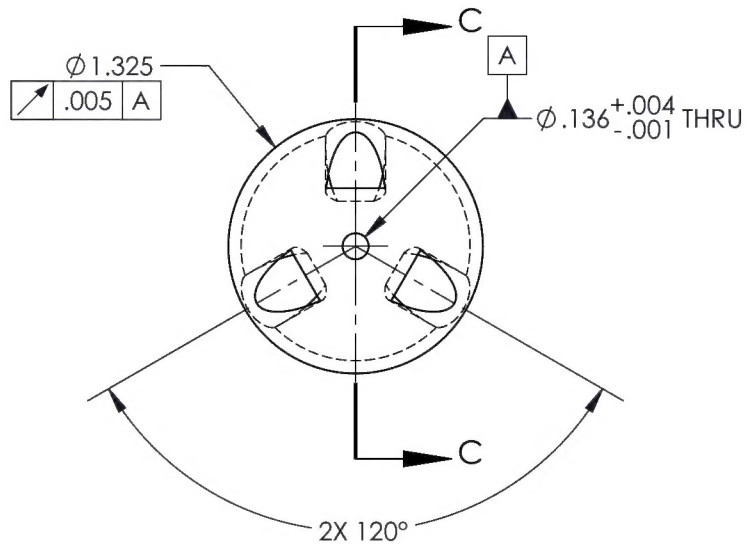
①

ROLLER FIXTURE

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-1	REV 1
MAT'L DRILL ROD	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX \pm .005	HEAT TREAT RC 55-60
.XX \pm .01	FINISH
.X \pm .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 1:1	DATE 5/20/2013
SHEET 2 OF 10	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



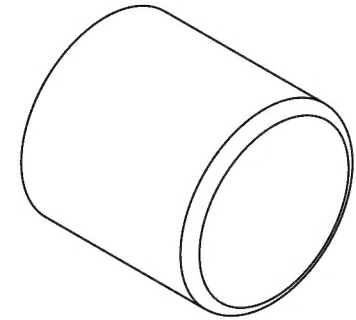
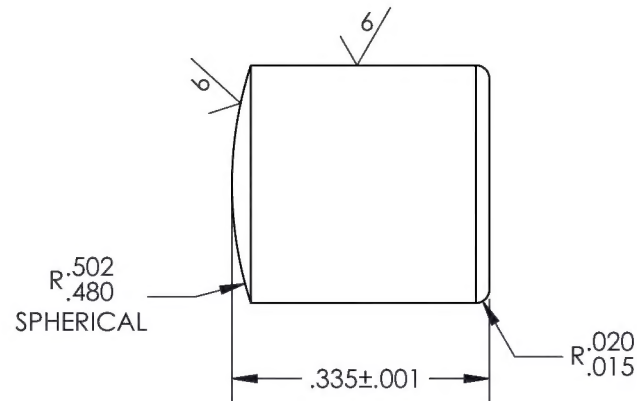
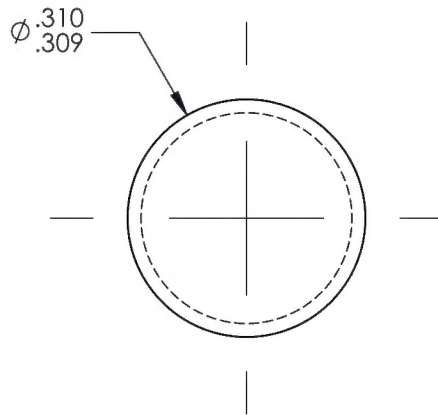
SECTION C-C

③
RETAINER

DART AEROSPACE	
TITLE TR-ROLLER SWAGING TOOL	
DWG NO. RBST2854-3	REV 1
MAT'L BRONZE RND BAR	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± .5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	212-310-701-103
SCALE 1:1	DATE 5/20/2013
	SHEET 3 OF 10

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

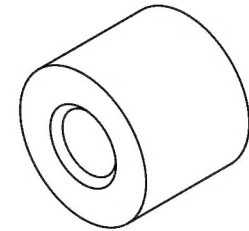
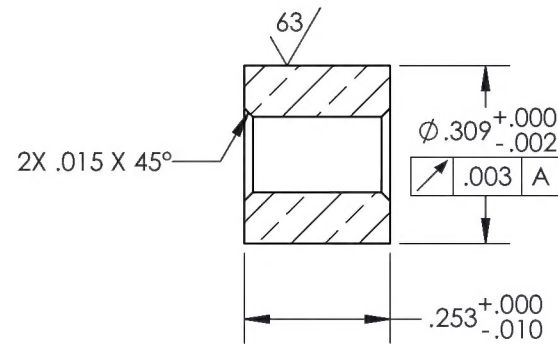
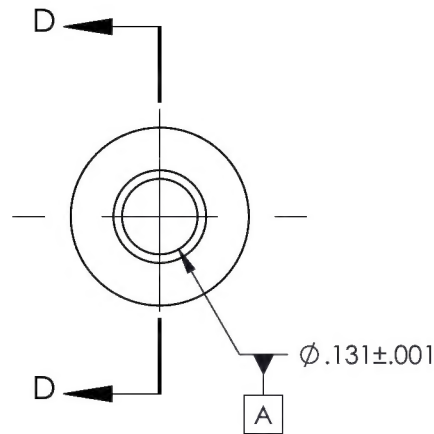


(5)
ROLLER

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-5	REV 1
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>P. Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT RC 55-60
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 4:1	DATE 5/20/2013
SHEET 4 OF 10	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



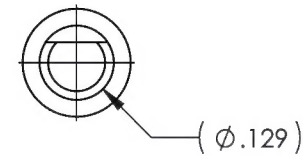
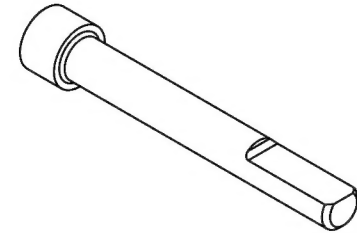
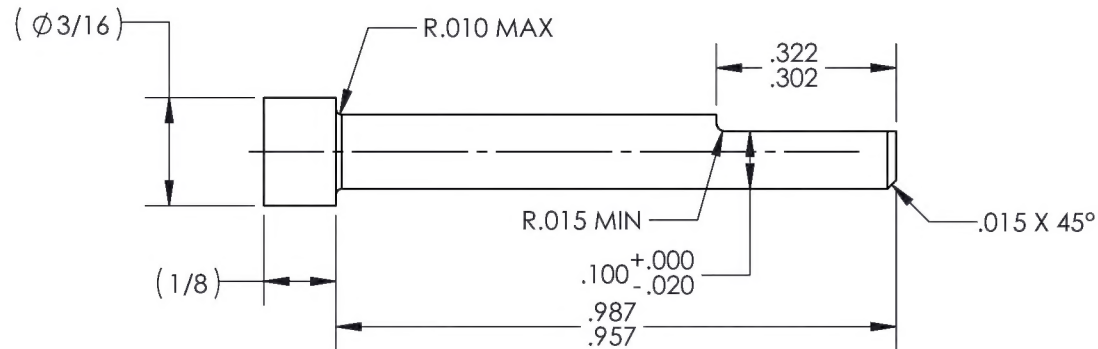
SECTION D-D

(-7)
GUIDE

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-7	REV 1
MAT'L BRONZE RND BAR	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	212-310-701-103
SCALE 3:1	DATE 5/20/2013
	SHEET 5 OF 10


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0185	-9 CH'D DIM WAS Ø.241 IS (Ø.188), WAS Ø.129 +.000 -.001 IS (Ø.129).	10/15/2014	DJN	JAG



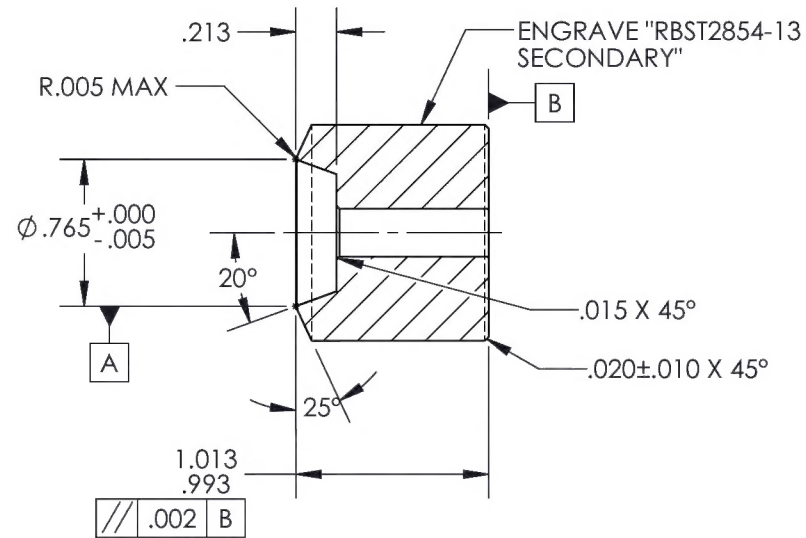
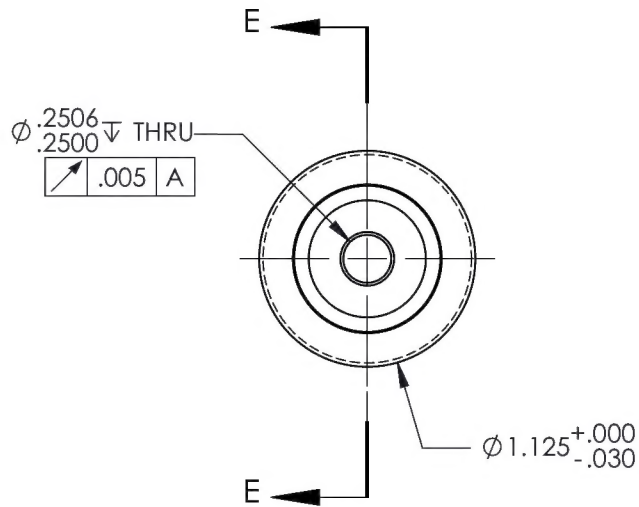
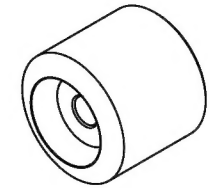
⑨
PIN

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-9	REV 1
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 3:1	DATE 5/20/2013
SHEET 6 OF 10	

			
TITLE TRI-ROLLER SWAGGING TOOL			
DWG NO. RBST2854-11			REV 1
MAT'L 4140 Q & T		DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1		HEAT TREAT FINISH BLACK OXIDE	
1. BREAK ALL SHARP EDGES .015 x .45" OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC USED ON MODEL 212-310-701-103	
SCALE 1:1	DATE 5/20/2013	SHEET 7 OF 10	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1	14-0185	-13 CH'D ENGRAVE NOTE.	10/15/2014	DJN
				JAG



SECTION E-E

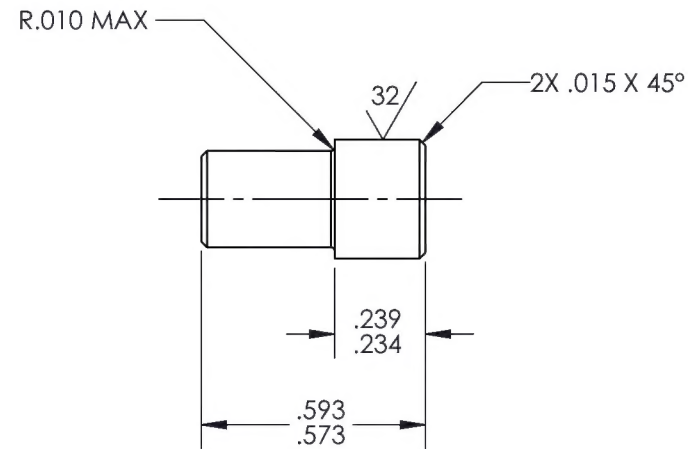
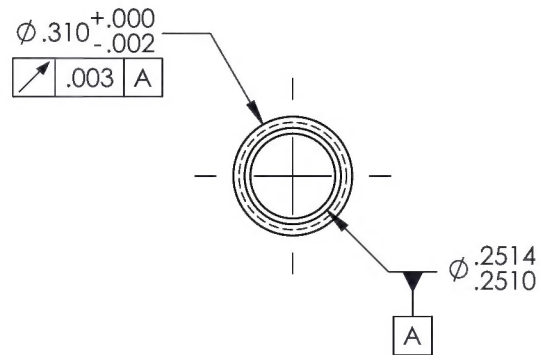
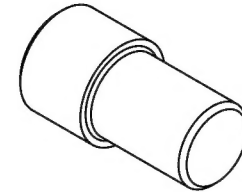
(-13)

SECONDARY SEAT

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-13	REV 1
MAT'L 4140 Q & T	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 1:1	DATE 5/20/2013
SHEET 8 OF 10	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



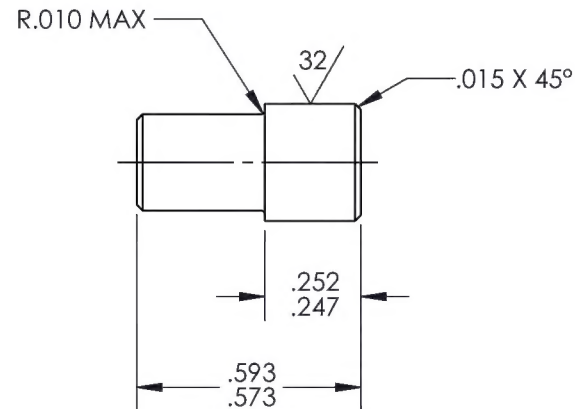
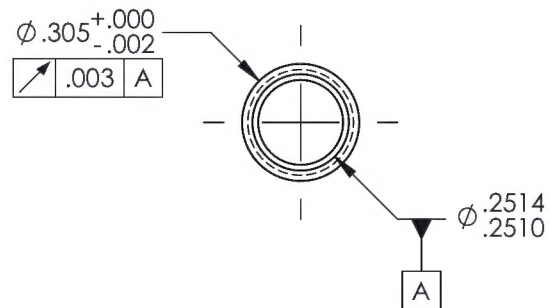
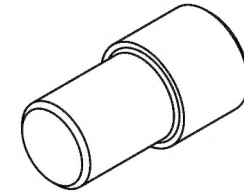
(-15)

LOCATING PIN

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-15	REV 1
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 2:1	DATE 5/21/2013
SHEET 9 OF 10	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-17)

LOCATING PIN

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-17	REV 1
MAT'L 1018	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH BLACK OXIDE
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 2:1	DATE 5/21/2013
SHEET 10 OF 10	